

82043

March-22-12 10:33:31 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

50

50

Reference:

Run Start *NR1*

Stop *NR2*

Date:

100		0.00			
100	Hardinge CNC LATHE SMALL				
Hardinge	Memo	0.00	52	Ø	SL 1263123
Hardinge CNC Lathe Small	Machine as per Folio FA962				
110	QC2- Inspect parts off machine FAI/FAIB	0.00			
110					
QC	Memo	0.00	52	Ø	SL 1263123
Quality Control					
120	QC8- Inspect parts - second check	0.00			
120					
QC	Memo	0.00			SL 1263123
Quality Control					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82043

82043

Page 2

March-22-12 10:33:31 AM

Item ID: D4170-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bushing
 Start Date: 22/03/2012 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 50.00 *50* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
125						52	0	BE12/03/29	
Skidtubes	Memo	0.00							
Skidtubes	1- clean crossbolt spacer with ultra brigh aluminum cleaner before storing.								
130	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
130						52	0	BE12/03/29	
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00							
140									12/13/29
QC	Memo	0.00							
Quality Control									

R 603-29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March-22-12 10:33:34 AM

Page 1

Work Order ID: 82043

82043

Parent Item: D4170-1

D4170-1

Parent Item Name: Bushing

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD IPP
Rev:A 10.11.02 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No.			100	f	429.4440	0.2666	14.03158			

M6061T6T0 375W 058

6061-T6 RD Tube .375 x.058W

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT014	429.444	
116920	0.578	
119087	13.685	
119376	270	
119644	0.171	
119678	66	
120633	79.01	

14.2 B 12/03/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

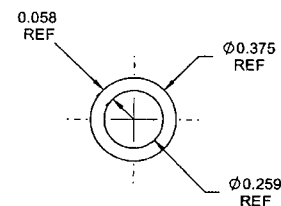
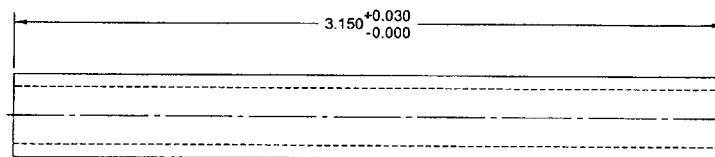
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 82043 MLJ
12/03/22



D4170-1 SPACER

RELEASED
 2010-11-01

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, $\phi 3/8$ OD X 0.058 WALL
 PER WW-T-700/8, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
 REF DART SPEC. M6061T6T0.375W.058
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

B	ADD -3 (SHEET 2)	CP	10.10.25
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	JP		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.25		

DART AEROSPACE USA, INC.
 PORT HADLOCK, WA

DRAWING NO.
D4170

TITLE
SPACER

REV. B
 SHEET 1 OF 2

SCALE
 NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

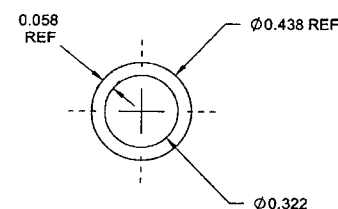
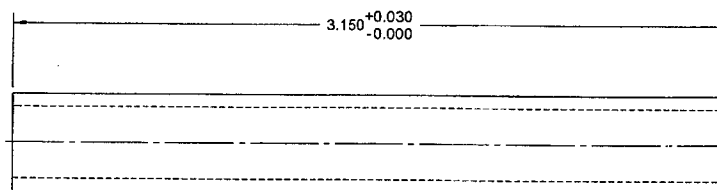
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

82043



△ D4170-3 SPACER

RELEASE
2010-11-01

NOTES:

1) MATERIAL: 6061-T6 ROUND BAR, Ø7/16 OD
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T6R0.438

OR

6061-T6 OR 6061-T62 TUBING, Ø7/16 OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.438W.058

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	GP	PORT HADLOCK, WA	
CHECKED	JB	DRAWING NO.	REV. B
MFG. APPR.		D4170	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
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